

Work Order ID 70039 -2

Wednesday, May 25, 2011 1:03:40 PM

SBR



Page 1

Item ID: D3371-041

Accept



Setup Start



Revision ID:

Item Name: Pedal Lock Assembly

SBR

Accept

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: SBR

Date: 11/05/2011 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
----------	--------------

D3371	Rev B
-------	-------

120



Small Fab

0.00

Small Fab

Memo

0.00

- 1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply locktite to lock body nut.

Qty	Part Number	Description	Batch
A/R	262	Locktite	ML17951

130



Small Fab

0.00

Small Fab

Memo

0.00

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

SBR 11/10/11

GS 10/7/18 O

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

140

Operation
Description

Small Fab

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Small Fab

Memo

0.00

Small Fab

- 1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371.
 2- Identify as D3371-041 & attach keys
 3- Record the Key Number on page 4

SP 11/10/18

①

150



QC5- Inspect part completeness to step on W/O

0.00

S ualol18

④

QC

Quality Control

160

Identify as per dwg & Stock Location: 492

0.00

11/10/18

Packaging

Packaging

Memo

0.00

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

W10/18 JG

MF
11-10-18

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 1:03:37 PM

Page 1
3

Work Order ID: 70039



Parent Item: D3371-041



Parent Item Name: Pedal Lock Assembly

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

238-028 		Purchased	No			120	Each	238.0000	2	8	<i>Sb 11110/18</i>		
-------------	--	-----------	----	--	--	-----	------	----------	---	---	--------------------	--	--

3/16" Dowel Pin .5" long

Location	Loc Qty	Loc Code
ST399	238	
106673	98	
108114	99	
17848	41	

AN526C832R6 		Purchased	No			120	Each	358.0000	4	16	<i>Sb 11110/18</i>		
-----------------	--	-----------	----	--	--	-----	------	----------	---	----	--------------------	--	--

Screw

Location	Loc Qty	Loc Code
ST327	358	
16612	358	

D2728-7 		Manufactured	No			120	Each	0.0000	0	0	<i>Sb 11110/18</i>		
-------------	--	--------------	----	--	--	-----	------	--------	---	---	--------------------	--	--

Dart Logo label

D3371-1 		Manufactured	No			120	Each	0.0000	1	4			
-------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Pedal Lock Base

D3371-3 		Manufactured	No			120	Each	3.0000	1	4	<i>Sb 11110/18</i>		
-------------	--	--------------	----	--	--	-----	------	--------	---	---	--------------------	--	--

Pedal Lock Cover

Location	Loc Qty	Loc Code
GA	3	
69634	3	

700 46

Sb 11110/18

1

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 70039



Parent Item: D3371-041



Parent Item Name: Pedal Lock Assembly

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

D3373-7



Manufactured No

120 Each 0.0000

1 4

SB 11/10/18

①

Cam Lock

D3385-3



Manufactured No

120 Each 109.0000

1 4

SB 11/10/18

①

Hinge

Location	Loc Qty	Loc Code
----------	---------	----------

ST051	109	
	109	

④

CBL-1240



Purchased No

130 f 385.7460

1.6666 7.017263



Cable

Location	Loc Qty	Loc Code
----------	---------	----------

ST284	385.746	
	85.746	

SB 11/10/18 ①

CBL-460



Purchased No

130 Each 82.0000



Loop Sleeve

Location	Loc Qty	Loc Code
----------	---------	----------

ST284	82	
	82	

②

③

8

SB 11/10/18

D3384-1



Manufactured No

130 Each 0.0000



Cyclic Sock

AN960-416



NAS1449F0463P Purchased No

140 Each 0.0000



Washer

M75032

M116702

①

2

2

SB 11/10/18

SB 11/10/18

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 3

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Parent Item: D3371-041



Parent Item Name: Pedal Lock Assembly

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

HX-81

Purchased

No

140

Each

27.0000

1

4



1/4"-20 SHCS 3/8" long



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST390	27	
114383	27	

Sp n(10|18

✓ 2

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

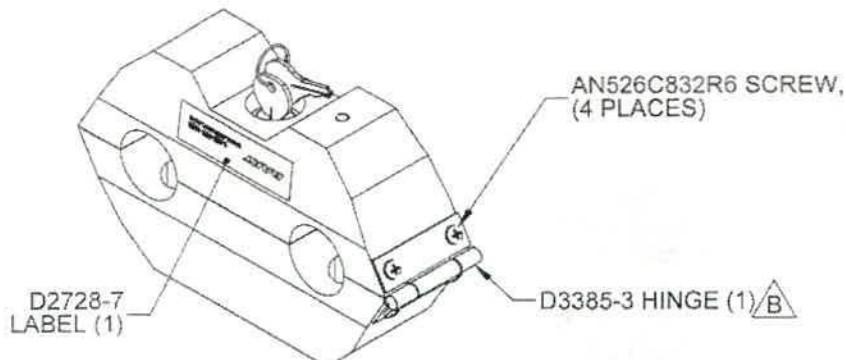
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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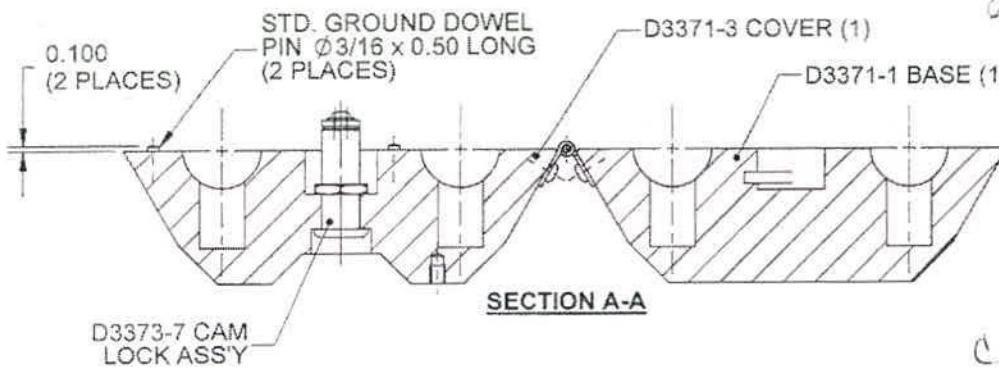
DART

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CHECKED	APPROVED	DRAWING NO.	REV. B
		D3371	SHEET 1 OF 4
DATE	05.03.22	TITLE	SCALE
		PEDAL LOCK	1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY

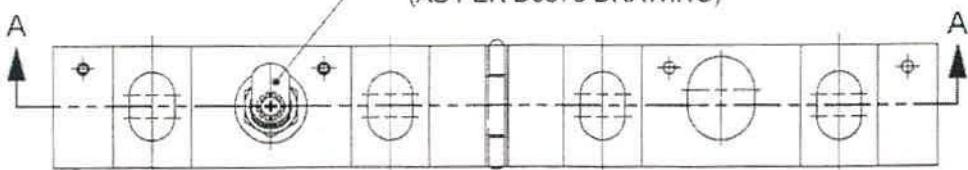
RELEASED
MP
05/04/28



SECTION A-A

CL 11/05/25

D3371-5 CAM (1),
AND SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1)
(AS PER D3373 DRAWING)



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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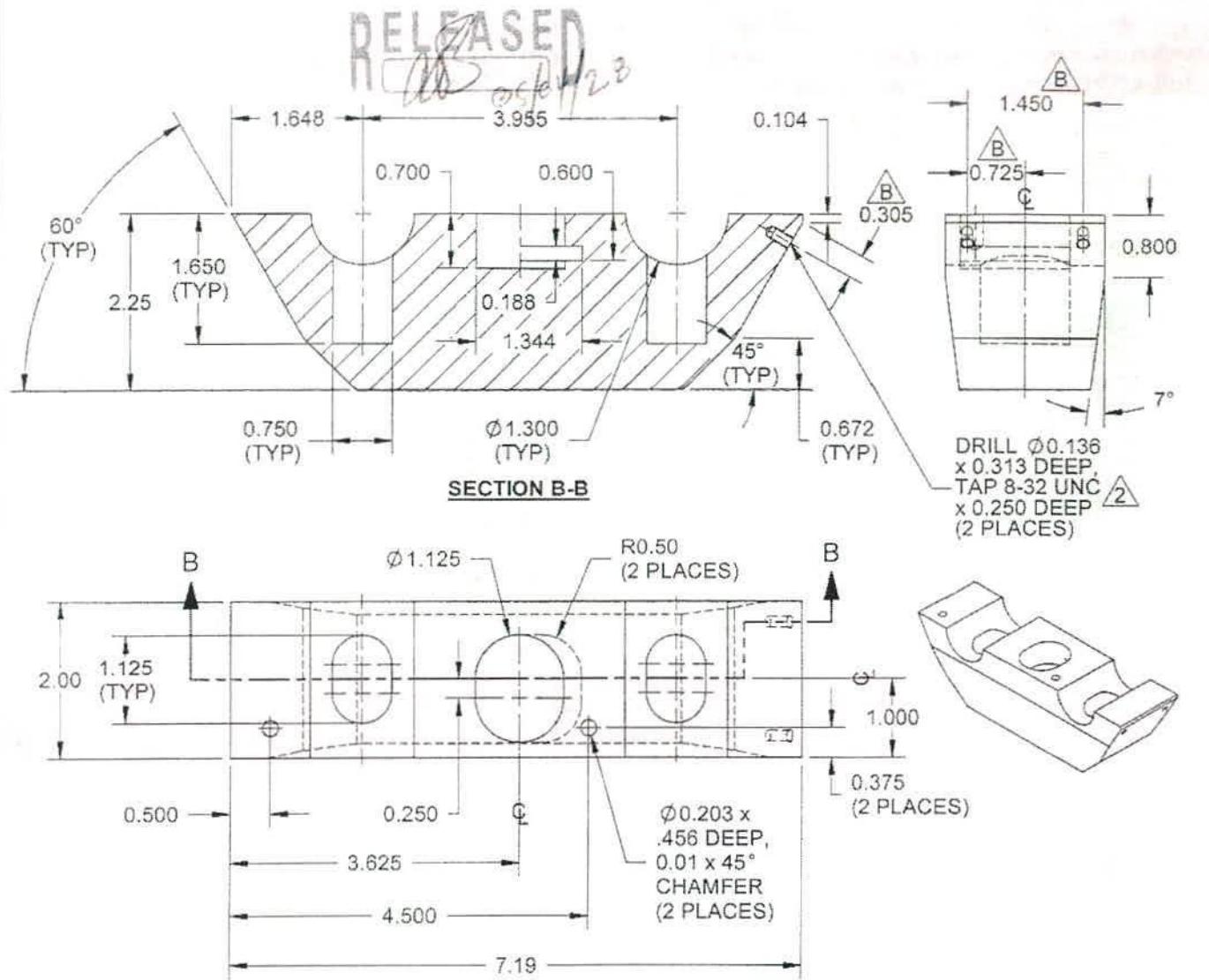
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3371
DATE	05.03.22	TITLE PEDAL LOCK

REV. B
SHEET 2 OF 4
SCALE
1:2



D3371-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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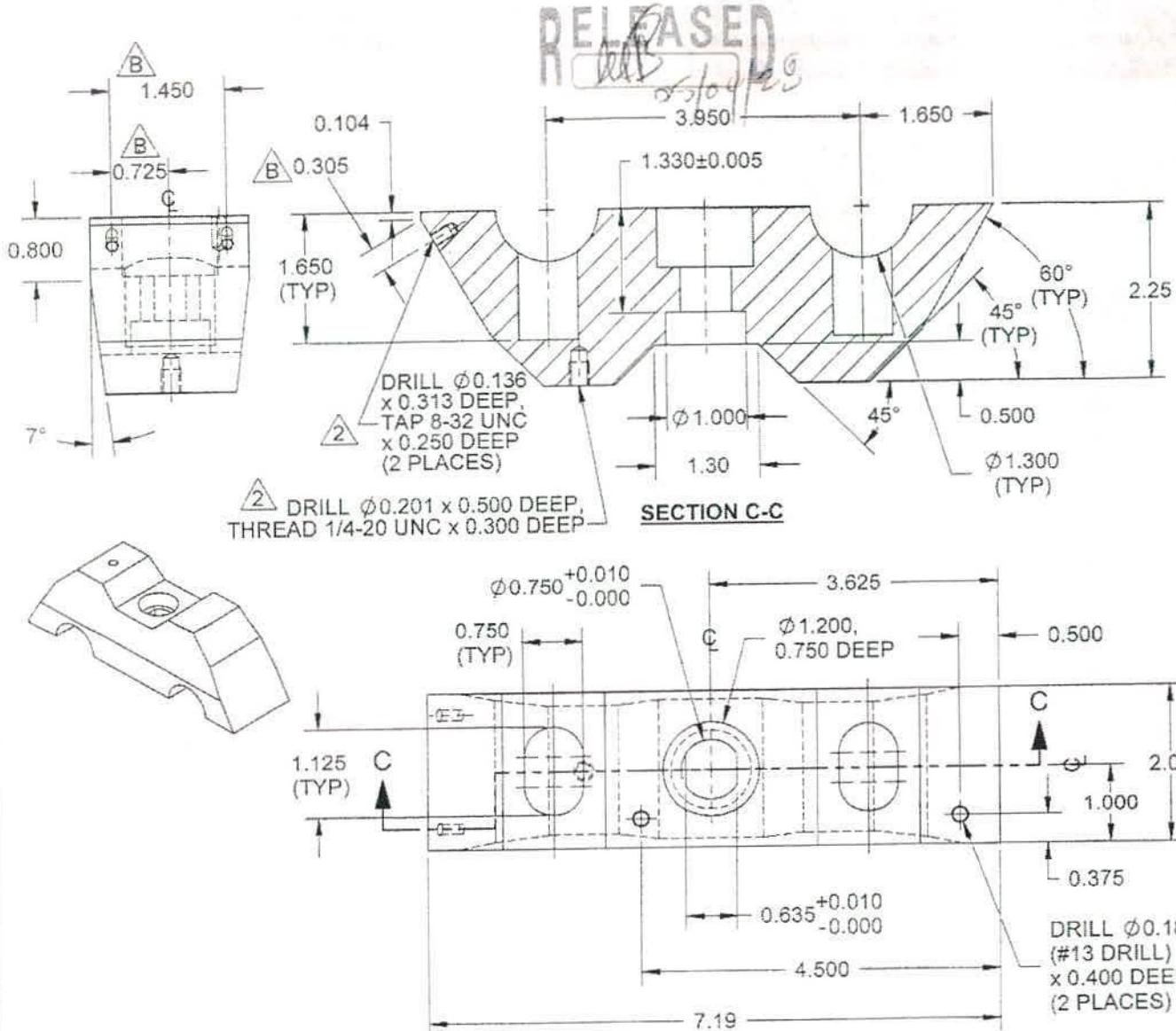
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 13	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK	SCALE 1:2	

**D3371-3 COVER****NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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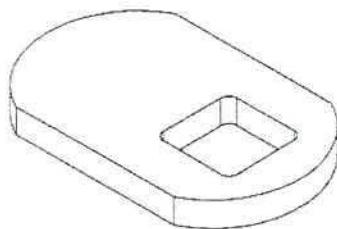
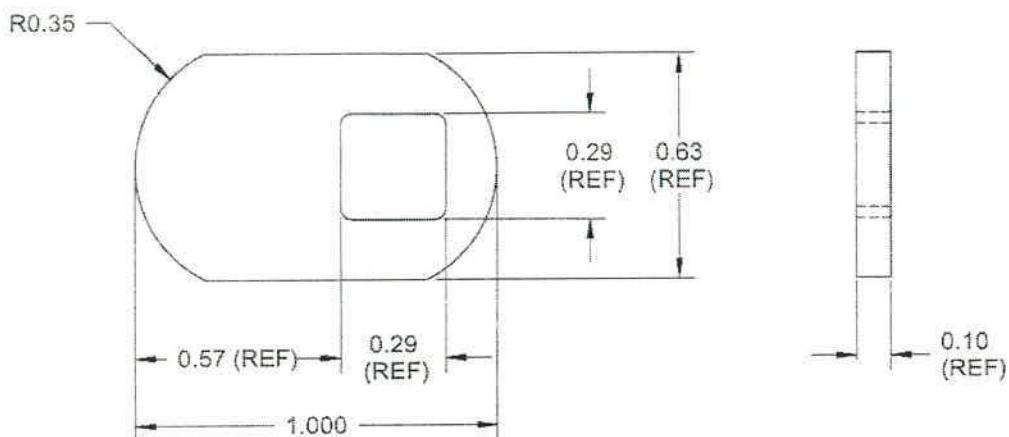
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B	SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1	

RELEASED
[Signature]
05/04/23

SPECIFICATION CONTROL DRAWING



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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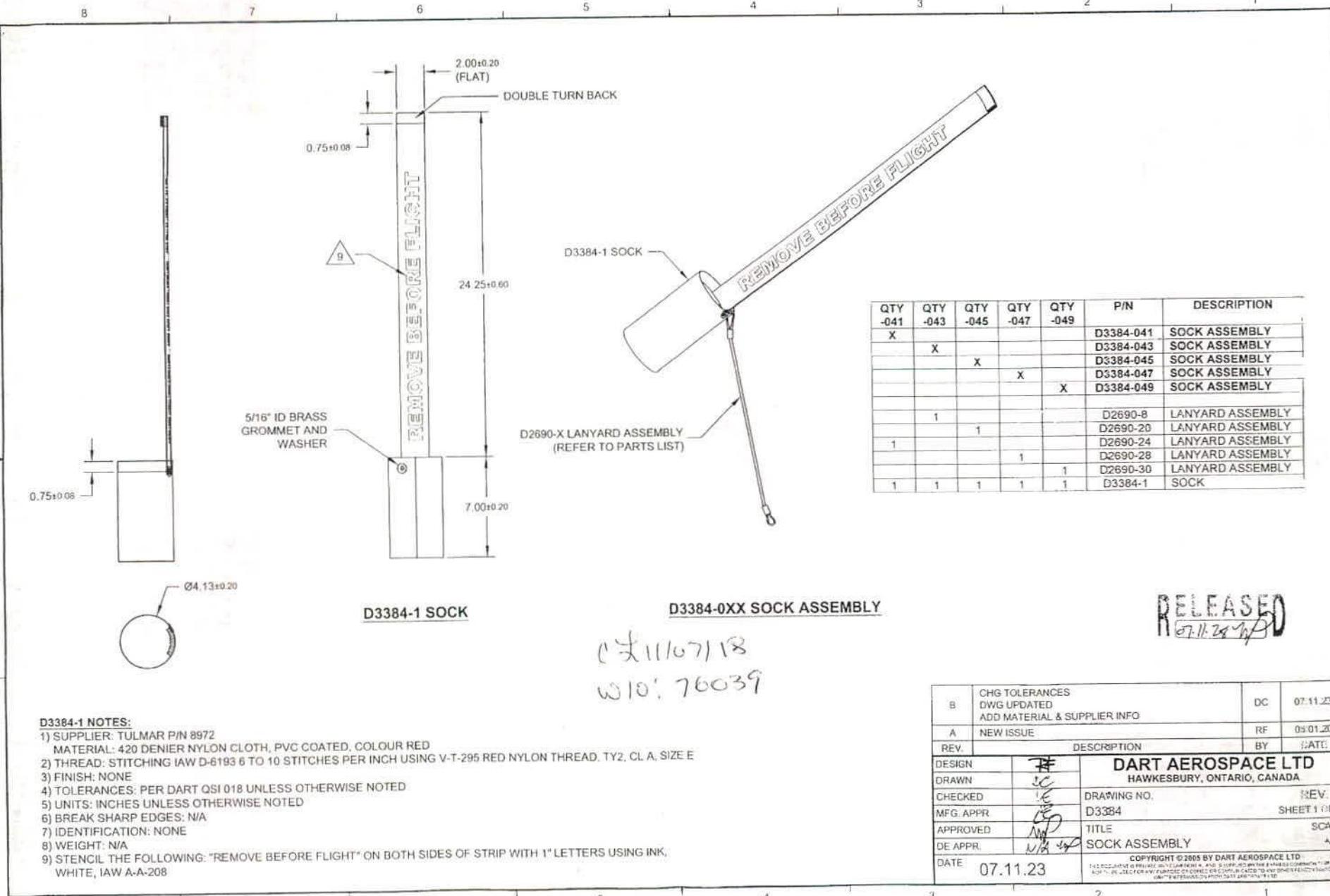
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D3384-1 NOTES:

- 1) SUPPLIER: TULMAR P/N 8972
MATERIAL: 420 DENIER NYLON CLOTH, PVC COATED, COLOUR RED
 - 2) THREAD: STITCHING IAW D-8193 6 TO 10 STITCHES PER INCH USING V-T-295 RED NYLON THREAD. TY2, CL A, SIZE E
 - 3) FINISH: NONE
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: NONE
 - 8) WEIGHT: N/A
 - 9) STENCIL THE FOLLOWING: "REMOVE BEFORE FLIGHT" ON BOTH SIDES OF STRIP WITH 1" LETTERS USING INK,
WHITE, IAW A-A-208

B	CHG TOLERANCES DWG UPDATED ADD MATERIAL & SUPPLIER INFO	DC	07.11.23
A	NEW ISSUE	RF	05.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>PF</u>	DART AEROSPACE LTD	
DRAWN	<u>SC</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>LE</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>EG</u>	D3384	SHEET 1 OF 1
APPROVED	<u>MW</u>	TITLE	SCALE
DE APPR.	<u>N/A</u>	SOCK ASSEMBLY	ACTS
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